



Dart Aerospace Ltd.
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Canada

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D3639-3

Job Sheet 193706



Part No: D3639-3

Job Qty: 10 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		5/15/19	0.00	1.31	Waterjet - Flow	8/27/19	JRB
110	QC 2	10 pcs		5/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48	8/27/19	JRB
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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4/22/2019

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120 QC 8	10 pcs	5/15/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Small Fab - Brake NC - B4B	10 pcs	5/15/19	0.00 0.56	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	10 pcs	5/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical-B4B	10 pcs	5/15/19	0.00 0.93	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	

DAS
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AUG 27 2019 9:59

DAS 30 9:59 SEP 09 2019

DDAS
410
SEP 10 2019 9:59

SEP 11 2019

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				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	QC 7	10 pcs	5/15/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
170	Packaging 3-1 - Stock - B4B	10 pcs	5/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B

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				Packaging 3 - 22 - B4B	PC	ST234A
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
180 QC 21 - SA	10 pcs	5/15/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		
Part Op 100 - 1-Cut as per Dwg D3639 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - (QC8- Inspect parts - second check 130 - (Bend/Assemble as per dwg) Form as per Dwg D3639 140 - QC5- Inspect part completeness to step on W/O 150 - Chemical Conversion Coat per QSI005 4.1 160 - QC7-Inspect Chemical Conversion Coat 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M2024T3S.050	2024-T3 .050 Sheet	4.2771 sf (.42771 ea)	100-Waterjet - Flow - 1	S155209		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Flow - 1	M2024T3S.050	4	90	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order:	193706
Description: Doubler		Part Number:	D3639-3
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.624	/		VDC-22	
Ø0.191	+0.005/-0.001	0.193	/		Tape	
Ø0.098	+0.004/-0.001	0.098	/			
0.45	+/-0.030	0.450	/			
1.350	+/-0.010	1.351	/			
2.25	+/-0.030	2.25	/			
3.15	+/-0.030	3.14	/			
4.05	+/-0.030	4.06	/			
4.95	+/-0.030	4.96	/			
5.85	+/-0.030	5.86	/			
6.75	+/-0.030	6.75	/			
7.65	+/-0.030	7.65	/			
8.55	+/-0.030	8.54	/			
9.350	+/-0.010	9.352	/			
9.45	+/-0.030	9.48	/			
10.350	+/-0.010	10.352	/			
11.25	+/-0.030	11.23	/			
12.15	+/-0.030	12.16	/			
12.85	+/-0.030	12.87	/			
13.86	+/-0.030	13.80	/			
13.96	+/-0.030	13.94	/			
0.805	+/-0.010	0.806	/			
1.00	+/-0.030	1.00	/			
2.100	+/-0.010	2.103	/			
3.30	+/-0.030	3.30	/			
2.000	+/-0.010	2.000	/			
2.590	+/-0.010	2.590	/			

Measured by: JRB	Audited by: DAS 40	Prototype Approval:	N/A
Date: 8/27/19	Date: AUG 27 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Skid-tube ☐ ☐ ☐ Engineering ☐ ☐ ☐ Machining ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐		MRB (QSI042)	
Date: _____		Sequence #: _____		QTY Affected: _____			
Description Work Order Deviation		Disposition		Completed By			
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐		FAULT CATEGORY Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Other/Details: _____		Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐			
		Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐		Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐			